Date:

Tuesday, 10/06/2008 3:14:29 PM

User:

. Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

Estimate Number

: 39803 : 11180

P.O. Number This Issue

Prsht Rev.

First Issue

Written By

Comment

: 10/06/2008

S.O. No. :

: NC

: // : 38606B Type

: LARGE FAB ASSY

Part Number Drawing Number

Drawing Name

: D2282043

: SADDLE ASSEMBLY

Project Number

: D2282 REV E

Drawing Revision

: N/A : E

Material **Due Date**

: 30/06/2008

Qty:

50 Um:

Each

Previous Run

Checked & Approved By

: Est Rev:A

Removed from 9 Digit

05-12-02 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D2281



1.0000 Each(s)/Unit Total:

50.0000 Each(s)

Jack Saddle

Pick:

Comment: Qty.:

Qty Part Number

Description Batch

Saddle 1 D2281

B37445

D22827



Pick:

Comment: Qty.:

Qty Part Number 2 D2282-7

Description Batch

2.0000 Each(s)/Unit Total: 100.0000 Each(s)

tube <u>537850</u> x **Q**/

3.0

LARGE FAB 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly

A/R

ER316L SS

Filling Rod M/01 744

Dwg Rev: _

VISUAL WELDING INSPECTION

4.0

QC9



Comment: VISUAL WELDING INSPECTION



W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector		
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Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Approval	Annaval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector
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Tuesday, 10/06/2008 3:14:29 PM Date: Julie Lecocq User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: SADDLE ASSEMBLY Job Number: 39803 Part Number: D2282043 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT WORK TO CURRENT STEP 5.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- grind weld flush, take all welding markes out and deburr holes 7.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 50 Identify and Stock

FINAL INSPECTION/W/O RELEASE

Location: GA

9.0 QC21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





W-08-08-

W/O:		WORK ORDER CHANGES									
DATE	STEP		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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			QA: N/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
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DELEASED BELEASED BELEASED BELEASED	DATE 05.06.07 A B C D E	94.10.14 95.03.23 97.10.20 05.03.16 05.06.07	DRAWING NO. D2282 TITLE HANDLE TUBES NEW ISSUE RE-DESIGN CORRECTED NUMI REDESIGN D2282 D2282-5 304 SS R0.063 x 0.063	BERING SCHEME -5; 0.795 WAS S WAS 303 SS;	0.750
DELEASED	DATE 05.06.07 A B C D	95.03.23 97.10.20 05.03.16	HANDLE TUBES NEW ISSUE RE-DESIGN CORRECTED NUMI REDESIGN D2282 D2282-5 304 S3	BERING SCHEME -5; 0.795 WAS S WAS 303 SS;	SCALE 1:1
H TOO TO V	05.06.07 A B C D	95.03.23 97.10.20 05.03.16	HANDLE TUBES NEW ISSUE RE-DESIGN CORRECTED NUMI REDESIGN D2282 D2282-5 304 S3	-5; 0.795 WAS S WAS 303 SS;	0.750
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BS/09/16			D2282-5 304 S	S WAS 303 SS;	
BS/07/1	E	05.06.07	D2282-5 304 S3 R0.063 x 0.063	S WAS 303 SS; WAS RO.080 X	0.030
	1 -			$\overline{\bot}$	3
2.375_0.000	<u>-</u>	0.795	Ø0.4	(F	0.675 REF)
D2282-3	D	D2282-	· (RF	\ \ \	
D2282-3/-7 TUBE; 1) MATERIAL: T304/T316 3 2) BREAK ALL UMARKED S 3) ALL DIMENSIONS ARE IT 4) TOLERANCES ARE PER	SHARP EDGES N INCHES	0.005 TO (0.010	, <u> </u>	**************************************
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R0.350				Ø0.700)
0.080 x 45° (REF)		_		E UNCON SUBJEC	RETURN TO NGINEERING NTROLLEID TO AMEND
,	D.	D2282-5	1,		THOUT NOTICE ORK ORDE
<u>D2282-5 STEM:</u> 1) MATERIAL: AISI 304 STA	INLESS STEE	I (REE DAR	T SPEC. M304R0 7	50) F	

DRAWN BY

DESIGN

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2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

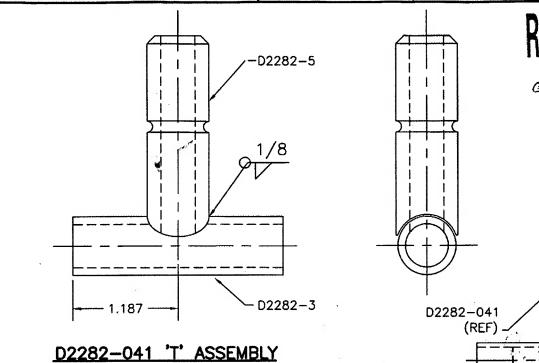
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Part No:	PAR #: Fault Category:	Fault Category:	NCR: Yes No DQA: _	Date:
			QA: N/C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)						že.		
		Description of NC		Corrective Action Section B	Verification	Approval	Approval	
DATE	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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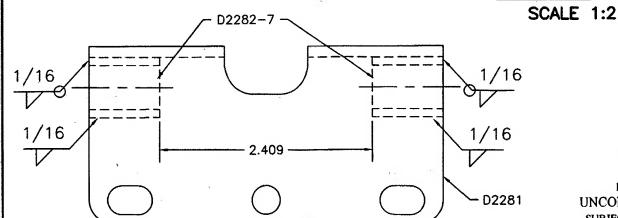
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CHECKED	APPROVED	DRAWING NO.	rev. e
U'	land	D2282	SHEET 2 OF 2
DATE	1 400	TITLE	SCALE
05.06.07		HANDLE TUBES	1:1



WELD ASSEMBLY PER DART QSI 004

D2282-043 (REF)





D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

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Part No:	PAR #:	Fault Category: _	 NCR: Yes No	DQA:	Date:	_
			QA: N/C	losed:	Date:	_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE STEP	Description of NC		Corrective Action Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector					
	Section A	Initial Action Description Chief Eng Chief Eng					Sign & Date				
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